

Work Order ID 81530

81530

Page 1

March-15-12 9:28:18 AM

Item ID: D3403-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 15/03/2012 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 29/03/2012 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3403 | D |

100 Hardinge CNC LATHE SMALL 0.00
100
 Hardinge Memo 0.00
 Hardinge CNC Lathe Small 1- Turn as per Folio FA558 & Dwg D3403
 Folio Rev: AA Dwg Rev: D
 2-Deburr

101 ✓ off/sl
veloster

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

101 ✓ off/sl
veloster

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

SA 1203/28 101 ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 81530

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March-15-12 9:28:18 AM

Item ID: D3403-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bushing

Stop ***NS2***

Start Date: 15/03/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *ST 42*

0.00

130

Packaging

Memo

0.00

Packaging

101 x SP 12-03-30

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/3/30
CZ 12/03/30

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

March-15-12 9:28:23 AM

Page 1

Work Order ID: 81530

81530

Parent Item: D3403-3

D3403-3

Parent Item Name: Bushing

Start Date: 15/03/2012

Required Date: 29/03/2012

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-03-07 As per Rev B JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R0.750 | | Purchased | No | | | 100 | f | 44.8700 | 0.206 | 21.68421 | | | |

M303R0 750

**

303 Round Bar 0.750

| Location | Loc Qty | Loc Code |
|-------------|---------|----------|
| MAT028 | 44.87 | |
| 117328 | 13.242 | |
| 117798 | 4.004 | |
| 118509 | 4.08 | |
| 119346 | 0.645 | |
| 120145 | 10.566 | |
| 29 → 120603 | 12.333 | |

~~21.68421~~ 6.28

M121157 X VAR 14.84
15.57

OK 12/03/28

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 81530 |
| Description: Bushing | | Part Number: | D3403-3 |
| Inspection Dwg: D3403 Rev: C | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------|------------------|--------|--------|----------------------|----------|
| 2.165 | +0.010/-0.000 | 2.169 | ✓ | | Dial Caliper | BC 05 |
| 0.060 | +/-0.005 | .061 | ✓ | | | I |
| Ø0.257 | +0.010/-0.000 | .257 | ✓ | | | |
| Ø0.750 | +/-0.010 | .749 | ✓ | | | |
| Ø0.425 | +0.000/-0.002 | .424 | ✓ | | | |
| Ø0.313 x 60° | +/-0.010 x +/-0.5° | .313 | ✓ | | | |
| R0.010 | +/-0.010 | .015 | ✓ | | | I |
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| Measured by: <i>AK</i> | Audited by: <i>SA</i> | Preliminary Approval: |
| Date: 12/03/28 | Date: 12/3/28 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|--------------------|
| A | 06.04.12 | New Issue | KJ/JLM | |
| B | 08.02.28 | Dimensions updated | KJ/DD | |
| C | 11.03.08 | Dimensions updated per Dwg Rev C | KJ | <i>[Signature]</i> |

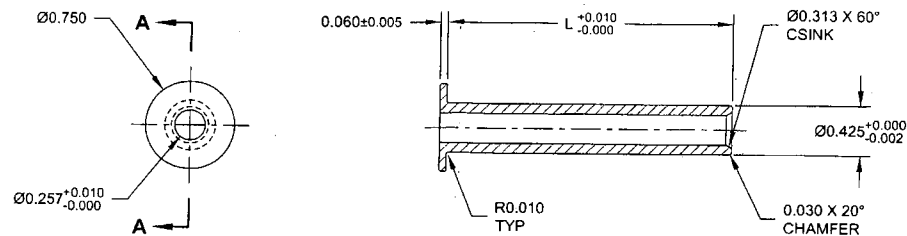
Dart Aerospace Ltd

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NOTE: Date & initial all entries



SECTION A-A

D3403-X BUSHING

| DART P/N | L | WEIGHT (lbs) |
|----------|-------|--------------|
| D3403-1 | 2.416 | 0.07 |
| D3403-3 | 2.165 | 0.06 |
| D3403-5 | 2.440 | 0.07 |



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 81530 MCT
12/03/15

RELEASED
2011-10-31

| | | | |
|------------|--|---|--------------|
| D | FOR -5, 2.440 WAS 2.500 (PER PAR 11-125) | XDF | 11.10.28 |
| C | REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029 | MB | 10.04.21 |
| B | ADD COUNTERSINK | PH | 06.01.23 |
| A | NEW ISSUE | PH | 05.03.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | XDF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. I |
| MFG. APPR. | <i>df</i> | D3403 | SHEET 1 OF 1 |
| APPROVED | <i>df</i> | TITLE | SCALE |
| DE APPR. | <i>df</i> | BUSHING | NT |
| DATE | 11.10.28 | COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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